

Work Order ID 155133***155133***

Page 1

Monday, January 09, 2017 11:28:17 AM

Item ID: D350-604-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-567 Stop ***NS2***
Item Name: Rear Locker Extender
Start Date: 6/1/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/3/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: **DAS 21** Date: **JAN 12 2017** Tooling: _____ Date: _____ Run Start ***NR1***
QC: **9-89** Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2273	LUR M 17/01/12								
D350-604-041	CUR 9 12/1/13								

100	Document Control	0.00				DAS 28			
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100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile and create labels per PPP D350-604-041

CHG009

CHG010**DAS 21**
9-89**See attachment****JUL 03 2017**

110	PURCHASING	0.00							DAS 13 9-89
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110

Purchasing

Purchasing

MemoIssue P/O: **34973**

Description: D350-604-041 Rear locker extender.

Manufacture as per dwg D2273

Supplier: FDC Composites Inc.

Certification of Conformity and process sheet required.

***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF
THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE
FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Monday, January 09, 2017 11:28:17 AM

155133

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N900040100

Setup	Start	*NS1*
	Stop	*NS2*

Start Date: 6/1/2017	Start Qty: 1.00	*1*
Required Date: 7/3/2017	Req'd Qty: 1.00	*1*

Cust Item ID:
Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120	Packaging								
	Memo	0.00							
	Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached.								
	DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control	Check hole locations to template. DT 8824 Check process sheet and audit.								
140		0.00							
140									
Small Fab	Memo	0.05							
Small Fab	1- INSTALL DECALS AS PER DWG								

1x SP17-6-23

D 17.06.28 DAS
9
9-89

DAS
28
9-89
JUL 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 155133***155133***

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Item ID: D350-604-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-567 Stop ***NS2***
Item Name: Rear Locker Extender
Start Date: 6/1/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/3/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
						DAS 27 9-89 JUL 03 2017			
155	Pick Kit	0.00							
155									
Packaging	Memo	0.00							
Packaging	***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***								
						DAS 27 9-89 JUL 03 2017			
158	QC4- 100% Inspect kits for completeness	0.00							
158									
QC	Memo	0.01							
Quality Control									
						DAS 28 9-89 JUL 03 2017			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 155133***155133***

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Monday, January 09, 2017 11:28:17 AM

Item ID: D350-604-041

Accept

N900040100Setup Start ***NS1***

Revision ID: URF 16-567

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 6/1/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/3/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

160

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location:

PPP Rev: F9107DAS
28
9-89

JUL 03 2017

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.02

Quality Control

17/7/4 08DAS
21
9-89

JUL 03 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Monday, January 09, 2017 11:28:20 AM

Page 1

155133

D350-604-041

Required Date: 7/3/2017

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R
12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04
AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per
CHG006/ECN13-616 DDVERF:JLM IPP REV:U 14.05.28 as per
chg008/ecn14-563 DD verf:JLM IPP REV:V 15.03.13 remove cam lock and
washerDD verf:JLM IPP REV:W 15.03.25 ECN15-545 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-604-041P		Purchased	No			110	Each	0.0000	1	1			
D350-604-041P										**	IX SP 17-6-23		
Rear Locker Extender													
D2268		Manufactured	No			140	Each	13.0000	1	1			
D2268										**	DAS 27 9-89		
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		13							
					147069	7		6/13/2017				JUL 03 2017	
					148553	6		7/22/2017					
D2728-1		Manufactured	Yes			140	Each	-1.0000	1	1			
D2728-1										**	DAS 27 9-89		
Dart Logo Label Small													
D2269		Manufactured	No			155	Each	8.0000	1	1			
D2269										**	JUL 03 2017		
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		8							
					147070	2		6/13/2017				JUL 03 2017	
					148588	6		7/22/2017					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Monday, January 09, 2017 11:28:20 AM

Work Order ID: 155133

155133

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 6/1/2017

Required Date: 7/3/2017

Start Qty: 1.00

Required Qty: 1.00

D5062-041

Manufactured No

155

Each

16.0000

1

1

D5062-041

Bracket Assembly

DAS
27
9-89

JUL 03 2017

Location

Loc Qty

Loc Code

ST147

16

145920

16

DAS
28
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
				Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
				Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
				Contamination ☐	Out of Sequence ☐	Part Moved ☐	
				Countersink ☐	Off-set ☐	Drawing ☐	
				Cut Too Short ☐	Mislabeled ☐	Finish ☐	
				Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
				Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER : ☐			

TABLE 1

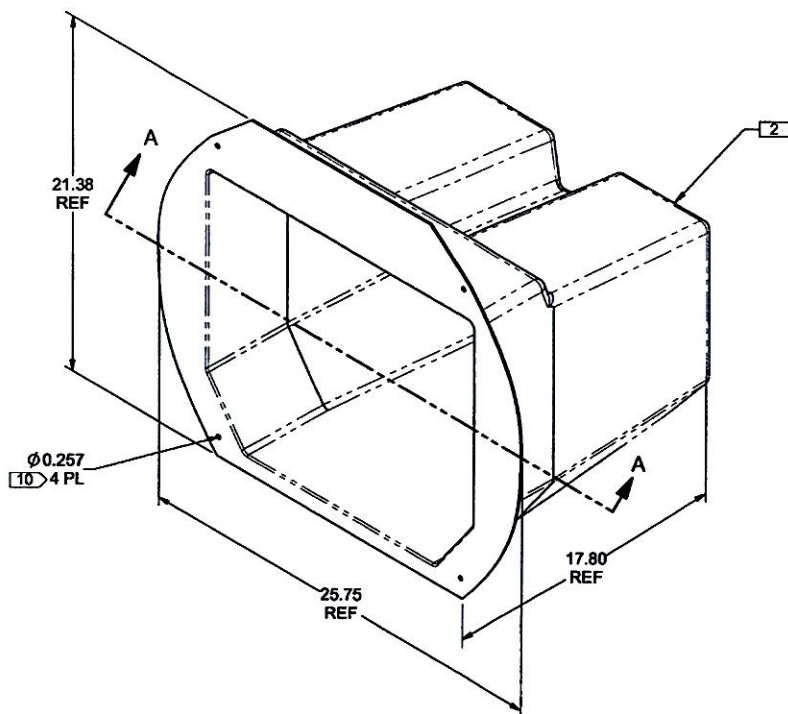
POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

NOTES:

- 1) MATERIAL: SEE TABLE 3
- 2) FINISH: SEE TABLES 1, 2, & 3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.5- 7.5 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM
- 10) TRIM & DRILL PER DT9905. OPEN HOLES TO Ø0.257
- 11) CONSTRUCTION: SEE TABLES 1 & 2
- 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED



D2273 REAR LOCKER EXTENDER

TABLE 3

MATERIAL USED	DESCRIPTION
GELCOAT	55X3535 WHITE GELCOAT
FIBER GLASS MAT	OWENS CORNING 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	DION 7704
PRIMER	TEMPO 4500-PB-23G (GREEN)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

SEE TABLE 1

SEE TABLE 2

SECTION A-A

M	CHANGE GELCOAT TO 55X3535 WHITE GELCOAT, REMOVE PAINT FINISH OPTION (NOTE 2)	DB	16.05.19
L	ADD PAINT OPTION (NCR 15-5408)	CP	15.10.19
K	LAYUP AND MAT'L PER FDC COMPOSITES PROCESS	CP	15.03.12
J	CHANGED GELCOAT TO 4314-001 DURA FR WHITE	ML	13.12.10
I	CHANGE GELCOAT TO POLYCOR 2330PAWK745	SFM	13.08.13
H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.15
G	ADD MANUFACTURING OPTION B, ZN B5-1	DC	12.08.08
F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE

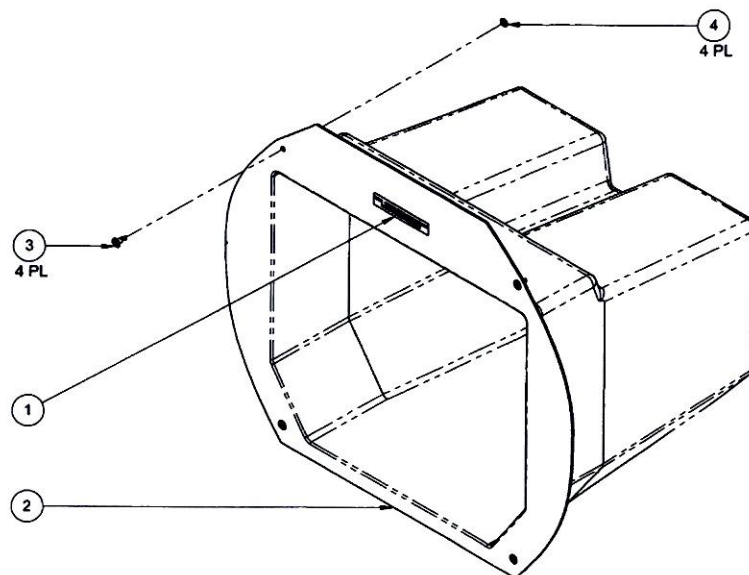
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. M
MFG. APPR.	DD	D2273	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	350 REAR LOCKER EXTENDER	NTS
DATE	16.05.19		

RELEASED
2017-01-11
EWN 17-501

APPROVED
DM

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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
	X	D350-604-041	REAR LOCKER EXTENDER ASSEMBLY
1	1	D2268	PLACARD
2	1	D2273	REAR LOCKER EXTENDER
3	4	2600-6	CAMLOCK STUD
4	4	2600-LW	RETAINING WASHER



D350-604-041 REAR LOCKER EXTENDER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 5.5 to 7.5 lbs
- 8) INSTALL D2268 PLACARD IN LOCATION SHOWN, CENTERED ON FLANGE

C	REMOVE D2728-1, D2729-1 DECALS (ZN CS-1) REVISED RELATED NOTES, UPDATED PART WEIGHT	ML	13.12.16
B	INCORPORATE DSI 9470 (ZN D7-1), UPDATE DWG TO CURRENT STANDARDS. ADD D2728-1 PLACARD AND ORIENTATION NOTE (ZN C3-1). ADD D2729-1 (ZN CS-1).	DC	12.02.07
A	NEW ISSUE	CP	02.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D350-604-041 RLE ASSY THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	ML		
CHECKED	AP		
MFG. APPR.	JLM		
APPROVED	MP		
DE APPR.	DS	REV. C SHEET 1 OF 1 SCALE NTS	
DATE	14.01.02		

3

3

3

3

3



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO34973

Purchase Order Date 1/17/2017 9:02:37 AM
PO Print Date 1/31/2017

Page Number 1 of 3

Order From : VC-FDC01
FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED \$

Contact Name
Vendor Phone 450-357-1344 ext303

Ship To Contact
Ship To Phone
Ship Via: Journey Freight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D350-604-041P	Rear Locker Extender	6/5/2017 Yes 6/5/2017		1.00 Each	\$705.00	\$705.00
	PO REVISED AS PER QUOTE # 1199 AS PER DWG D2273 REV. M / D350-604-041 REV. C BI55133 PLEASE NOTE REARLOCKER UNDER NEW REV. M						
	DAS 9 9-89						
						Line Total:	\$705.00
2	D350-604-041P	Rear Locker Extender	6/5/2017 Yes 6/5/2017		1.00 Each	\$705.00	\$705.00
	AS PER DWG D2273 REV. M / D350-604-041 REV. C BI55134 PLEASE NOTE REARLOCKER UNDER NEW REV. M						
						Line Total:	\$705.00

PO Instructions: NOTE: NO BILLING PRIOR TO SHIPPING

Note:

1/31/2017

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tel.: 450 357-1344

Shipping Order

15/06/2017

Order : 2640
Reference : PO 34973/1-5

Customer: Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Ship To
DART AEROSPACE LTD
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7
Tel.: 1 613 632-9577

Item No.	Description	Qty	Qty. Delivere	B/O Qty
D350-604-041P	REAR LOCKER EXTENDER PO item: 34973/1 Lot: 2017-02-22 As per DWG.D2273 Rev. M B155133	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 34973/2 Lot: 2017-02-27 As per DWG.D2273 Rev. M B155134	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 34973/3 Lot: 2017-03-02 As per DWG.D2273 Rev. M B155135	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 34973/4 Lot: 2017-03-06 As per DWG.D2273 Rev. M B155136	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 34973/5 Lot: 2017-03-08 As per DWG.D2273 Rev. M B155137	1		

Shipping : _____
Package No : _____
Merchandise Received : _____

Ref. : _____



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 34973

Revision: NC

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number</u>	<u>Description</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
1 ✓	1 ✓	D350-604-041P ✓	D2273 Rev M	350 Rear Locker Extender	B155133 ✓	DAE001-111 ✓	2017-02-22 ✓
2	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155134	DAE001-118	2017-02-27
3	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155135	DAE001-126	2017-03-02
4	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155136	DAE001-128	2017-03-06
5	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155137	DAE001-135	2017-03-08

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: Marjorie S
Marjorie Geoffrion, Quality Inspector

Date: 2017-06-16



Gamme de Fabrication

# LOT	2017-02-02
# SÉRIE(ID)	DAE001-111

Nom de Gamme :	Rear locker extender - DART
# de Gamme (et rev.) :	DAE001 Rev. D
Nom pièce - Client :	350 Rear locker extender - DART AEROSPACE
# de Dessins (et rev.) :	D2273 Rev. J

ID: BISS133 / 1

Fiche suiveuse

[10-60]	Préparation	Moule, Espace de travail, Matière premières, Consommables	#23 09 FEV. 2017
[70-90]	Finition/Peinture	Appliquer Gel coat, Inspecter	#23 #3 #26 22 FEV. 2017 22 FEV. 2017 21 FEV. 2017
[100-150]	Laminage	Laminer, Démouler, Inspecter	#19 #21 #26 #23 21 FEV. 2017 22 FEV. 2017 21 FEV. 2017 22 FEV. 2017
[160-200]	Usinage	Percer, Découper, Ébavurer, Inspecter, Sabler	#30 9 MAR. 2017
[210-230]	Finition/Peinture	Primer, Inspection	#3 28 MAR. 2017
240	Expédition	Emballer, Expédier	#8 15 JUIN 2017

Gamme préparé par :	Guillaume G.Jasmin
Gamme révisée par :	Francis Lavigne-Larente
Gamme vérifiée par (Chefs d'équipe) :	Maxime Gagné
Gamme approuvée par :	Maxime Gagné
Date d'émission :	2015-01-14

Avant de produire le CofC, toutes les étapes et les informations requises des gammes subséquentes reliées à ce produit ont été complétées et remplies

Inspecteur

 Qualité

Informations à remplir :

Cases grises pâles

Inspection :

Matières premières

Résine	1028612	2017-05-17	Dion 7704
Norox (Résine)	41049	2017-08-01	MEKP-9
Norox (Gel coat)	41049	2017-08-01	MEKP-9
Gel coat blanc	702-284	2017-03-22	Polycor 2330PAWK745-SSX 3535
Mat ¾ oz/pi²	1505/100174-1	N/A	¾ oz Chopped Strand Mat (Owens Corning Or Equivalent)
Fibre de verre 7725	4294874	N/A	Hexcel 7725 Fiber Glass
Noyau DIAB F40 1/8po	N/A	N/A	, 1/8 thick
Apprêt (Primer) (Vert)	18316	2018-05-01	Tempo 4500-PB-23G (Vert)
Durcisseur pour apprêt (hardener)	18317	2018-05-01	Tempo 4500-C-23
Attache mécanique (Camloc)	1745658	N/A	2600-5
Rondelle de retenue pour Camloc	508980	N/A	2600-LW

Moule : MOU306 ou MOU309	FMS	Sarrau
Pompe à vide	55NC	Lunettes de sécurité
Jig de découpe et perçage : GAB350	Peel ply	Soulier de protection
Jig de finition et d'inspection : GAB355	Film perforé	Gants
Conformateurs : GAB356 à GAB364 (Qte 9)	Bleeder breather	Masques à cartouches
Pince pour installer Camloc : OUT951	Bag big blue	
Outil pour installer rondelle de retenue : OUT952	Ruban scellant (Dum Dum)	

Annexe 1
Formulaire de résine (RES-DAR001)

MPS-300-93-31-007-NC	Démoulage 55NC
MPS-300-93-31-058-A	Composite part inspection
MPS-300-93-31-020-B	Edge finish after trimming
MPS-300-93-31-097-NC	Epoxy - Polyamide primer
MPS-300-93-31-084-NC	Protection et entreposage des pièces

Suivi des révisions

A	Révision d'une OP inspection, Ajout nouveaux moules et retrait d'un type de primer	2015-03-04	Guillaume G.Jasmin
B	Ajout des conformateurs, du gabarit GAB355, de l'installation des camlocs, inspection du poids et identification finale	2015-03-25	Guillaume G.Jasmin
C	Mise à jour de la case approbation qualité page 1	2015-04-02	Guillaume G.Jasmin
D	Ajout du noyau sur le contour de la pièce	2015-09-28	Philippe Paquette-B.

Section A : PRÉPARATION

10	<u>Remplir les informations requises sur la première page (cases grises pâles)</u> • Demander au coordonnateur de production (ID) • Inscrire les heures et les dates d'entrée et de sortie de département		#23 09 FEV. 2017
20	<u>Découper la fibre et les périssables (Peel ply, sac étanche...) selon l'ANNEXE 1</u> • ACHEMINER et REMPLIR la section « Matière premières » pour : - Fibre de verre 7725 - Mat ¾ oz	Annexe 1	#23 09 FEV. 2017
30	<u>Découper les noyaux selon l'ANNEXE 1</u> • ACHEMINER et REMPLIR la section « Matière premières » pour : - Noyau DIAB F40 1/8po	Annexe 1	N/A ⊗
40	<u>Préparer la résine selon RES-DAR001 (Gamme de formulation de résine)</u> ACHEMINER et REMPLIR la section « Matière premières » pour : - Résine - Norox	RES-DAR001	#28 22 FEV. 2017
50	PRÉPARER le moule - Cochez le moule utilisé : MOU306 ☒ , MOU309 ☐ ☒ Nettoyer et traiter le moule ☒ Poser le Masking tape <u>Si nécessaire, traiter le moule au 55NC</u> • Faire le test de pelage, s'il ne passe pas, appliquer une couche de 55NC et refaire le test.	Annexe 1 MOU306 ou MOU309 MPS-300-93-31-007	#23 21 FEV. 2017 #21 21 FEV. 2017

60

PRÉPARER l'espace de travail (pendant l'application du gel coat)

- ☒ Vérifier et préparer la pompe
- ☒ Préparer et distribuer les outils
- ☒ Protéger l'environnement de travail (tables, plancher, etc.)
- ☒ Vêtir l'équipement de protection personnel
- ☒ Partir la ventilation
- ☒ Vérifier l'ordre et la présence de tous les plis de fibre et des morceaux de noyau dans le sac

Position	Matériel	Initial employé
10F	¾ oz Chopped strand MAT	MF Jeani
20F	7725 Fibre de verre	MF Jeani
30F	7725 Fibre de verre	MF Jeani
40R	7725 Fibre de verre	MF Jeani
50C	Noyau DIAB F40 1/8po	MF Jeani
60R	7725 Fibre de verre	MF Jeani
70R	7725 Fibre de verre	MF Jeani
80F	7725 Fibre de verre	MF Jeani

#23

22 FEV. 2017

#21

22 FEV. 2017

Section B : APPLICATION GEL COAT

70

(GEL COAT) : ACHEMINER et REMPLIR la section « Matière premières » pour :

- Gel coat

#28

22 FEV. 2017

80

APPLIQUER le Gel coat (18 - 22 mils)

Heure d'application

07 h 45 min

Annexe
1

#3

22 FEV. 2017

90

Point d'inspection (Inspecteur Qualité) :

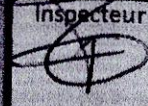
Épaisseur du gel coat : 18 - 22 mils

Qualité de l'application du gel coat : Uniforme et esthétique

Inspecteur

Qualité

Section C : LAMINAGE

100	Donner l'approbation (Inspecteur Qualité ou Chef d'Équipe) : Donner l'approbation pour que la pièce puisse être laminée (le gel coat est « mouleux » ou « tack free »)	Inspecteur  Qualité																																								
110	LAMINER <table border="1" style="width: 100%; border-collapse: collapse; margin-top: 10px;"> <thead> <tr> <th style="width: 30%;">Position</th> <th style="width: 70%;">Matériel</th> </tr> </thead> <tbody> <tr> <td>10F</td> <td>¾ oz Chopped strand MAT</td> </tr> <tr> <td>20F</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>30F</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>40R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>50C</td> <td>Noyau DIAB F40 1/8po</td> </tr> <tr> <td>60R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>70R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>80F</td> <td>7725 Fibre de verre</td> </tr> </tbody> </table> CONSOMMABLE <table border="1" style="width: 100%; border-collapse: collapse; margin-top: 10px;"> <tbody> <tr> <td style="width: 30%;">10F</td> <td style="width: 70%;">Peel Ply</td> </tr> <tr> <td>20F</td> <td>Release film non perforé</td> </tr> <tr> <td>30F</td> <td>Bleeder / Breather</td> </tr> <tr> <td>40F</td> <td>Conformateurs (Qte 9)</td> </tr> <tr> <td>50F</td> <td>Bagging bleu</td> </tr> </tbody> </table> ☒ S'assurer que tous les plis dans le tableau ont été laminés ☐ S'assurer que tous les conformateurs (Qte 9) sont en place par-dessus le Bleeder/Breather <table border="1" style="width: 100%; border-collapse: collapse; margin-top: 10px;"> <tbody> <tr> <td style="width: 40%;">Heure début laminage</td> <td style="width: 20%;">8</td> <td style="width: 20%;">h 15</td> <td style="width: 20%;">min</td> </tr> <tr> <td>Heure mise sous-vide (sac scellé)</td> <td>9</td> <td>h 00</td> <td>min</td> </tr> <tr> <td>Intensité du vide (25 inHg)</td> <td>0.9</td> <td></td> <td>inHg</td> </tr> </tbody> </table>	Position	Matériel	10F	¾ oz Chopped strand MAT	20F	7725 Fibre de verre	30F	7725 Fibre de verre	40R	7725 Fibre de verre	50C	Noyau DIAB F40 1/8po	60R	7725 Fibre de verre	70R	7725 Fibre de verre	80F	7725 Fibre de verre	10F	Peel Ply	20F	Release film non perforé	30F	Bleeder / Breather	40F	Conformateurs (Qte 9)	50F	Bagging bleu	Heure début laminage	8	h 15	min	Heure mise sous-vide (sac scellé)	9	h 00	min	Intensité du vide (25 inHg)	0.9		inHg	Annexe 1 GAB356 à GAB364 (Qte 9)
Position	Matériel																																									
10F	¾ oz Chopped strand MAT																																									
20F	7725 Fibre de verre																																									
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Heure mise sous-vide (sac scellé)	9	h 00	min																																							
Intensité du vide (25 inHg)	0.9		inHg																																							
120	LAISSER POLYMÉRISER la pièce sous vide pendant 2h	#21 22 FEB 2017																																								

#23

22 FEB 2017

#26

21 FEB 2017

21 FEB 2017

61#

#21

22 FEB 2017

N/A

130	DÉMOULER et IDENTIFIER la pièce ☒ Brancher le système d'air comprimé ☒ Écrire le numéro de pièce et la date sur un collant – # de lot (date de début) – # de série ID Ex : (AAAAAMMJ) – (DAE001-XXX) ☒ Découper une <u>pellicule de plastique protecteur bleu</u> et la coller sur le rebord et à l'intérieur de la partie blanche (Gel coat) (Voir Annexe-1) ☒ Placer la pièce sur la table d'inspection	Annexe 1	#26 21 FEV 2017 #19 21 FEV 2017
140	Nettoyer le moule - Enlever la résine durcie tout le tour du moule avec une spatule en plastique pour ne pas endommager le moule <u>Si nécessaire</u>, nettoyer le moule avec un chiffon légèrement humecté de nettoyant à moule (PMC) NE PAS TROP APPLIQUER DE "PMC"	Spatule en plastiqu e	#19 23 02 2017
Section D : USINAGE			
160	PERÇAGE ET DÉCOUPE : INSTALLER le Gabarit de perçage et découpe PERÇER la pièce - Perçer 4 trous avec un forêt F (Dia. .257 po) au travers des canons de perçage du Gabarit GAB350 DÉCOUPER la pièce - Retirer le Gabarit de découpe une fois terminé	GAB350 Annexe 1 Forêt F (Dia. .257 po)	#30 9 MAR 2017
170	SABLAGE : INSTALLER le Gabarit de finition et d'inspection GAB355 SABLER la pièce jusqu'à arriver à la dimension du Gabarit GAB355 (voir Annexe 1) RETIRER le Gabarit ÉBAVURER les arêtes vives	GAB355 Annexe 1 MPS- 300-93- 31-020	

180	2.1.3. Vérifier la conformité de la pièce (Dimensions) selon le no. de dessin et selon le MPS-300-93-31-058	Annexe 1 MPS-300-93-31-058 20170316	Inspecteur Qualité
-----	--	---	----------------------------------

190	SABLER légèrement l'extérieur de la pièce Papier 120 à 320 grains	#19 13 MAR. 2017	
200	NETTOYER les surfaces extérieures		#3 28 AVR. 2017

Section E : FINITION/PEINTURE

210	APPLIQUER le primer 2 couches d'environ 10 mils chacune	MPS-300-93-31-097	#3 MARS 28 AVR. 2017
220	INSTALLER les attaches mécaniques (Camlocs) (Qte 4) (voir Annexe 1) - Utiliser les pinces spécialisées (OUT951) pour insérer les Camlocs dans les trous - Utiliser l'outil spécialisé (OUT952) pour installer les rondelles de retenues	Annexe 1 Pince à Camloc (OUT951)	2 Mai 2017 J M
230	Inspection finale - Vérifier la finition (pinholes, surface inégale, etc...) - Vérifier s'il y a un panneau de contrôle relié à la pièce - Stamper le carré dans le coin inférieur droit de la première page - Identifier la pièce finale (voir Annexe 1) pour exemple et localisation - Poids de la pièce: 6.6 (LBS)	Annexe 1 MPS-300-93-31-058	Inspecteur #8 JUIN 2017 Qualité

Section F : EXPÉDITION

240	Emballer et expédier	MPS-300-93-31-084	#8 15 JUIN 2017
-----	----------------------	-------------------	--------------------

Work Order ID 155133

Monday, January 09, 2017 11:28:17 AM

155133

Page 1

Item ID: D350-604-041

Accept

N900040100

Setup Start

NS1

Revision ID: URF 16-567

Item Name: Rear Locker Extender

Stop

NS2

Start Date: 6/1/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/3/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

Date: JAN 12 2017 Tooling:

Date:

Run

Start

NR1

QC:

DAS

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2273

D350-604-041

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-604-041

CHG 21

CHG 21

DAS

21

DAS

see attachment

110

PURCHASING

0.00

110

Purchasing

Memo

0.00

Purchasing

Issue P/O: 34973

Description: D350-604-041 Rear locker extender.

Manufacture as per dwg D2273

Supplier: FDC Composites Inc.

Certification of Conformity and process sheet required.

EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

DAS

5

9-89

JUL 03 2017

JAN 17 2017



Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH90-4

Issue No.: 4

Approval Date: January 31, 1990

Issue Date: February 17, 2012

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

Eurocopter France AS 350 B, B1, B2, B3, BA, D
Eurocopter France AS 355 E, F, F1, F2, N, NP

Canadian Type Certificate or Equivalent:

H-83 (AS 350 Series); H-87 (AS 355 Series)

Description of Type Design Change:

Installation of Rear-Locker Extender

**Installation/Operating Data,
Required Equipment and Limitations:**

Installation of Rear-Locker Extender must be in accordance with Transport Canada Civil Aviation (TCCA) approved Dart Aerospace Ltd. Installation Drawing D350-604, revision C, dated December 6, 2011 or later TCCA approved revision.

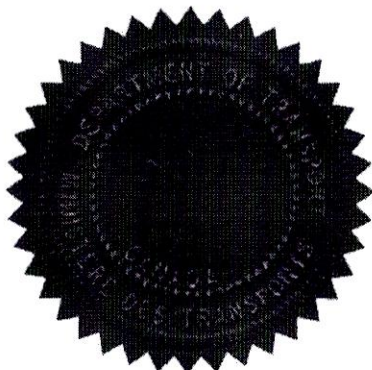
Operation of the Rear-Locker Extender must be in accordance with TCCA approved Dart Aerospace Ltd. Flight Manual Supplement FMS-D350-604, revision B, dated November 15, 2011, or later TCCA approved revision.

Maintenance of the Rear-Locker Extender must be in accordance with TCCA accepted Dart Aerospace Ltd. Instructions for Continued Airworthiness ICA-D350-604, revision 0, dated November 15, 2011, or later TCCA accepted revision.

Definition of Type Design Change: TCCA approved Dart Aerospace Ltd. Master Document List MDL-D350-604, revision A, dated February 2, 2012, or later TCCA approved revision.

Basis of Certification for affected areas: 14 CFR, Part 27 at amendment 27-21.

— End —



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.

Greg Oucharek
For Minister of Transport

Canada